



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-312
Job Sheet 183774



Part No: D350-591-312

Job Qty: 5 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/18

Job Tracking No: AIRBUS

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Large Fab-4		SLM
110	Large Fab	5 pcs	10/12/18	10/12/18	0.00	5.00	Large Fab 2		SLM
120	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC9		SLM
130	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC5		SLM
140	HandFinish	5 pcs	10/12/18	10/12/18	0.00	0.94	HandFinish1		D.R 18/10/13
150	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC7-2		CPC
180	Large Fab	5 pcs	10/12/18	10/12/18	0.00	5.00	Large Fab 2		DAS
190	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC10		38 DAS
200	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC5		9-89 38
210	HandFinish	5 pcs	10/12/18	10/12/18	0.00	0.94	HandFinish1		DR 18/10/14
220	Powdercoat	5 pcs	10/12/18	10/12/18	0.00	1.49	Powdercoat1		BR 18-10-16
230	HandFinish	5 pcs	10/12/18	10/12/18	0.00	0.94	HandFinish3		SL 18-10-16
240	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC3		OCT 17 2018 68
250	Packaging	5 pcs	10/12/18	10/12/18	0.00	0.00	Packaging1-3		OCT 2 2 2018 89
260	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC4		OCT 2 3 2018
270	Packaging	5 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-1		OCT 2 3 2018
275	DC	5 pcs	10/12/18	10/12/18	0.00	0.00	DC		OCT 2 3 2018
280	QC21-FG	5 Ea	10/12/18	10/12/18	0.00	0.00	QC21		OCT 2 3 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & 3 2018
Descriptions: Dwg D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 9:10 OVEN TEMPERATURE: 320° FINISH TIME: 9:15

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (2 ea)	90-Start up Operation	5104284
D3219-1	Plate	10 Ea (2 ea)	90-Start up Operation	51086616
D3272-1	Step	5 Ea (1 ea)	90-Start up Operation	5114279

5717

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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			Completed By																																																																				
			Lead hand / Supervisor Approval Verification																																																																				
			QC / QA Coordinator Approval																																																																				
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D3065-041	Step Leg Assembly	5 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	10 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	10 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	40 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	10 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	20 Ea (4 ea)	250-Packaging
D2618	Bushing	10 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	10 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	10 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	5 Ea (1 ea)	250-Packaging
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging

5114110
 5113167
 5077525
 5101329
 5089302
 5092504
 5116213
 5118035
 5104552
 5113208
 5114310
 5094592
 5094597
 5083541
 5095293
 5092780
 5093773

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	10	131	0
	D3219-1	10	105	0
	D3272-1	5	1	0
180-Large Fab	D3065-041	5	18	0
	D3066-1	10	130	0
	MS20600-AD4W4	80	245	0
250-Packaging	AN3-35A	10	373	0
	AN4-13A	40	756	0
	AN5-36A	10	318	0
	D2230-3	20	179	0
	D2618	10	155	0
	D2856-400-720	10	226	0
	D3235-1	10	259	0
	D3278-041	5	0	0
	MS21042L3	10	3,077	0
	MS21042L4	40	4,437	0
	MS21042L5	10	820	0
	NAS1149D0363J	20	2,097	0
	NAS1149D0463J	80	6,590	0
	NAS1149D0563J	20	1,526	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Reweld _____ Scrapped _____ Use-as-is _____ Suspected Unapproved _____
Date : _____	Step #: _____
Description Work Order Deviation	

DART AEROSPACE

Container No: S114764

Part: D350-591-312

Job No: 183774

Serial No/Batch: S114764

Inspector: _____

Exp Date: _____

Instructions: TC STC SH92-6 Issue 16a FAA STC SH967NE 04/12/21, BRAZIL 1

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Root Cause			FAULT CATEGORY		
Environment	☐	No Re-verification	☐	Pressure/Forced	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐		
Misidentified	☐	Past Due	☐	OTHER :	

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]

OCT 22 2018

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY